Work Order ID 83191 Page 1 April-13-12 1:01:26 PM D412-698-011 Item ID: Accept *N900040100* Setup Start **Revision ID:** Cabin Door Roller, LH Item Name: 13/04/2012 Start Qty: 2.00 **Start Date: Cust Item ID: Required Date:** 27/04/2012 **Req'd Qty:** 2.00 **Customer:** Reference: Run Process Plan: MLJ Date: 12/04/13 Tooling: Approvals: Date: Date: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Set Up/ Tool # Plan Accept Reject Reject Work Center ID **Description Run Hours** Code Qty Qty Number Stamp Draw Nbr **Revision Nbr** IIN D412-698 Rev E 100 DOCUMENT CONTROL *100* DC Memo Document Control Photocopy bluefile and create labels per PPP D412-698-011 CHG003 110 Pick Kit 0.00 *110* Packaging 0.00 Memo Packaging 120 QC4-100% Inspect kits for completeness *120*

QC

Quality Control

Memo

Dart Aeros	pace Ltd
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W/O:		*	V	ORK ORDER CHANC	GES					*	
DATE	STEP	PRO	CEDURE CH	EDURE CHANGE By					Approval Chief Eng / Prod Mgr	Approval QC Inspector	
									1.0		
Part No:		PAR #:	Fault Ca	tegory:	_ NCF	l: Yes I	lo DQ	A:	Date:		
	R		Disposit	Disposition: QA: N/C Closed: _							
NCR:		V	VORK OR	DER NON-CONFORM	ANCE	(NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section Initial Action Description			Sign & Verification Section C			Approval Chief Eng	Approval QC Inspector	
		Section A	Chief Eng	Chief Eng		Date	Secu	on C	Chief Eng	QC inspector	
A	V.									- T	
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Work Order ID 83191 April-13-12 1:01:26 PM Item ID: D412-698-011 Accept *N900040100* Setup Start **Revision ID:** Cabin Door Roller, LH Item Name: Start Qty: 2.00 Start Date: 13/04/2012 Cust Item ID: **Req'd Qty:** 2.00 **Required Date:** 27/04/2012 **Customer:** Reference: Run Date: Approvals: **Process Plan:** Tooling: Date: QC: SPC (Y/N): ____ Date: Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject **Work Center ID** Description **Run Hours** Code **Qty** Oty Number Stamp 130 0.00 Packaging *130* Packaging 0.00 Memo Packaging Identify and pack for shipping as per PPP D412-698-011 Location:

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

140

QC

140

Quality Control

MLJ 12 (08/23 1208:23

Insp.

Page 2

Dart	Aeros	pace	Ltd
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W/O:			WORK ORDER CHANGES								
DATE	STEP	PRO	CEDURE CH	IANGE	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
		(4									
Part No		PAR #:	PAR #: Fault Category: NCR: Yes No DQA:								
	R	esolution:	Disposit	ion:	_ QA:	N/C CI	osed:		Date: _		
NCR: WORK ORDER NON-CONFORMANCE (NCR)											
DATE	STEP	Description of NC		ion B	Verifica			Approval	Approval		
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector	
										,	
			*								

Picklist Print

April-13-12 1:01:31 PM

Work Order ID: 83191

83191

Parent Item:

D412-698-011

D412-698-011

Parent Item Name: Cabin Door Roller, LH

Start Date: 13/04/2012

Required Date: 27/04/2012

Page 1

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:C04.02.26Change Qty of D3121-141 & remove D3121-145 from

Step 1,3KJ/DS

IPP Rev:D 08-01-28 change to rev D ECN 1104 DD

I	PP Rev:D 08-01-	·28 change to re	VD E	CN 1104 DI) 								
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3121-141 *D3121-141 Bracket Assembly	41 *	Manufactured	No			100	Each	12.0000	**	6 B &S	488		
				Location		Loc (_	Loc Code		i.			
				ST235	80097		12 12		_		-		/
D3121-143		Manufactured	No			110	Each	8.0000		2).	_		
D3494212	43								**	B84	4/3	8	p. 4
				Location		Loc C	<u>Oty</u>	Loc Code					
				ST235A	75031		8		-		-		
1					80098		4		_	-	-		
D3183-043 *D3183-04 Bracket Assembly	1 3*	Manufactured	No			110	Each	3.0000	**	2 B 85	1688	Ø	0 4
				Location		Loc C	<u>Oty</u>	Loc Code				- •	
•				ST235			3				-		(
D3+67=043		Manufactured	No		75033	110	3 Each	6.0000		(2)	_	B	76498
* 137-04 Bracket Assembly	13*								**	BFO	399		80
/ Diable 1 seemon				Location		Loc Q	<u>oty</u>	Loc Code		^	12-5	2-2	2.
				ST235B			6		_	_s)			_
					79734		6			<u> </u>	B8340	-2 K	<u>×</u>)

W/O:		WORK ORDER CHANGES												
DATE	STEP	PRO	OCEDURE CH	EDURE CHANGE By					Approval Chief Eng / Prod Mgr	Approval QC Inspector				
										÷				
									3. 3.5					
Part No:		PAR #:	Fault Ca	tegory:	NCI	R: Yes I	No DQ	A:	_ Date: _					
	R	esolution:	Disposit	ion:	QA:	Date:								
NCR:		1	WORK OR	DER NON-CONFORM	IANCE	(NCR))			· .				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sec Action Description Chief Eng	ction B	Sign & Date	Verification Section C		Approval Chief Eng	Approval QC inspector				
Lec										·				
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April-13-12 1:01:31 PM

Work Order ID: 83191

83191

Parent Item:

D412-698-011

D412-698-011

Parent Item Name: Cabin Door Roller, LH

Start Date: 13/04/2012

Required Date: 27/04/2012

Start Qty: 2.00

Required Qty: 2.00

Manufactured

Manufactured

No

110 Each 12.0000

**

S	*D3202-1*
Ψ.	Cover

Location Loc Qty Loc Code ST236 17 78618 79797 8 ST236A -5 110 8.0000 Each

B83506 50

Location	Loc Oty	Loc Code
ST241A	8	
70294	8	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES													
DATE	STEP	PROC	EDURE CHANG	GE		Ву	Date Qty	Qty Approval Chief Eng / Prod Mgr	Approval QC inspector						
								7.5	3						
					,										
Part No		PAR #:	_ Fault Catego	ory:	lo DQA:	DQA: Date:									
	R	esolution:	_ Disposition:		Q/	A: N/C Clo	sed:	Date: _							
NCR:		W	ORK ORDER	R NON-CON	FORMANC	E (NCR)									
DATE	STEP	Description of NC Section A	Initial Chief Eng	orrective Actio Action Des	cription	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC inspector						
				4											
2															

6.0 PARTS LIST - CABIN DOOR MODIFICATION KIT

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

,Qty	Qty	Qty	Qty	Qty	Qty		
-011	-012	-013	-017	-019	-021	Part Number	Description
─X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	Х					D412-698-012	CABIN DOOR ROLLER KIT, RH
		Х				D412-698-013	DOOR HANDLE KIT
			Х			D412-698-017	REPLACEMENT DOOR TRACK KIT
				Х		D412-698-019	BEARING OVERHAUL KIT
					Х	D412-698-021	REPLACEMENT SHIM KIT
/3	3					D3121-141 /	BRACKET ASSEMBLY
9 1						-D3121-143	BRACKET ASSEMBLY
<i></i>	1					D3121-144	BRACKET ASSEMBLY
11-	1					D3137-043	BRACKET ASSEMBLY
1-1-	'					D3183-043	BRACKET ASSEMBLY
<u> </u>	1					D3183-044	BRACKET ASSEMBLY
-9-	9-	<u> </u>	9			D3199-1	-BRACKET
1 1	1		 1			-D3202=1	COVER
						50000 4	LIANDIE
		4				D3203-1	HANDLE
		1		ļ <u>.</u>		D3220-041	DOUBLER
		1				D3220-042	DOUBLER
1 (2				D3220-3	DOUBLER
				7		D3121-21	BOLT
i				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
1:					4	D3238-15	SHIM
li		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
Ti Ti	<u> </u>	16				MS24694-S98	SCREW
1		<u> </u>		1	1	MS24694-S101	SCREW

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